

Rush

Work Order ID 148806

148806

Page 1

July 08, 2016 10:35:44 AM

Item ID: PB67-43001-207W

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Square Tube Weldment

Start Date: 7/8/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 8/3/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: SAT Date: 7/12/16 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-07	D								

110

Weld per dwg A/R Aluminum rod Batch: 139826
Large Fab

110

Large Fab

Memo

0.00

JUL 19 2016

DAS
24
9-89

3 16-07-18 C

- 1- Cut to length as per dwg
2- Make a chamfer on both ends of tube
3- Drill holes as per dwg use drill jig DT10022
4- Make a chamfer on both side of the 4 holes
5- Deburr
6- Grind weld flush as per dwg

130

QC10- Inspect visual per QSI004- ground welds 0.00

130

QC

Memo

0.00

Quality Control

DAS
38
9-89

3 JUL 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause				FAULT CATEGORY																					
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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
135	QC5- Inspect part completeness to step on W/O	0.00							
135									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <i>Mezz 2</i>	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

DAS
38
JUL 19 2016

3 *C* 16-07-20

DAS
21
9-89
JUL 20 2016

DAS
21
9-89
JUL 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

July 08, 2016 10:35:44 AM

Page 1

Work Order ID: 148806

148806

Parent Item: PB67-43001-207W

PR67-43001-207W

Parent Item Name: Square Tube Weldment

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6TS1.000W.12 5		Purchased	No				f	209.8301		5.855368			

✓ ***M6061T6TS1 000W 125***

6061T6 SQ TUBE 1.00 x 1.00 x .125w

**

6 - 16-07-18

Location

Loc Qty

Loc Code

MAT028

209.830053

m128034

162.747053

m128248

47.083

Each

6.0000

**

6

3

JUL 19 2016

DAS
24
9-89

PB67-43001-223

Manufactured No

PR67-43001-223

Square Cap

Location

Loc Qty

Loc Code

Mezz2

6

133770

6

Each

3.0000

**

3

12

JUL 19 2016

DAS
24
9-89

PB67-43001-225

Manufactured No

PR67-43001-225

Bushing

Location

Loc Qty

Loc Code

Mezz2

3

112762

3

B148791 -> 12

DQA: _____ Date: _____



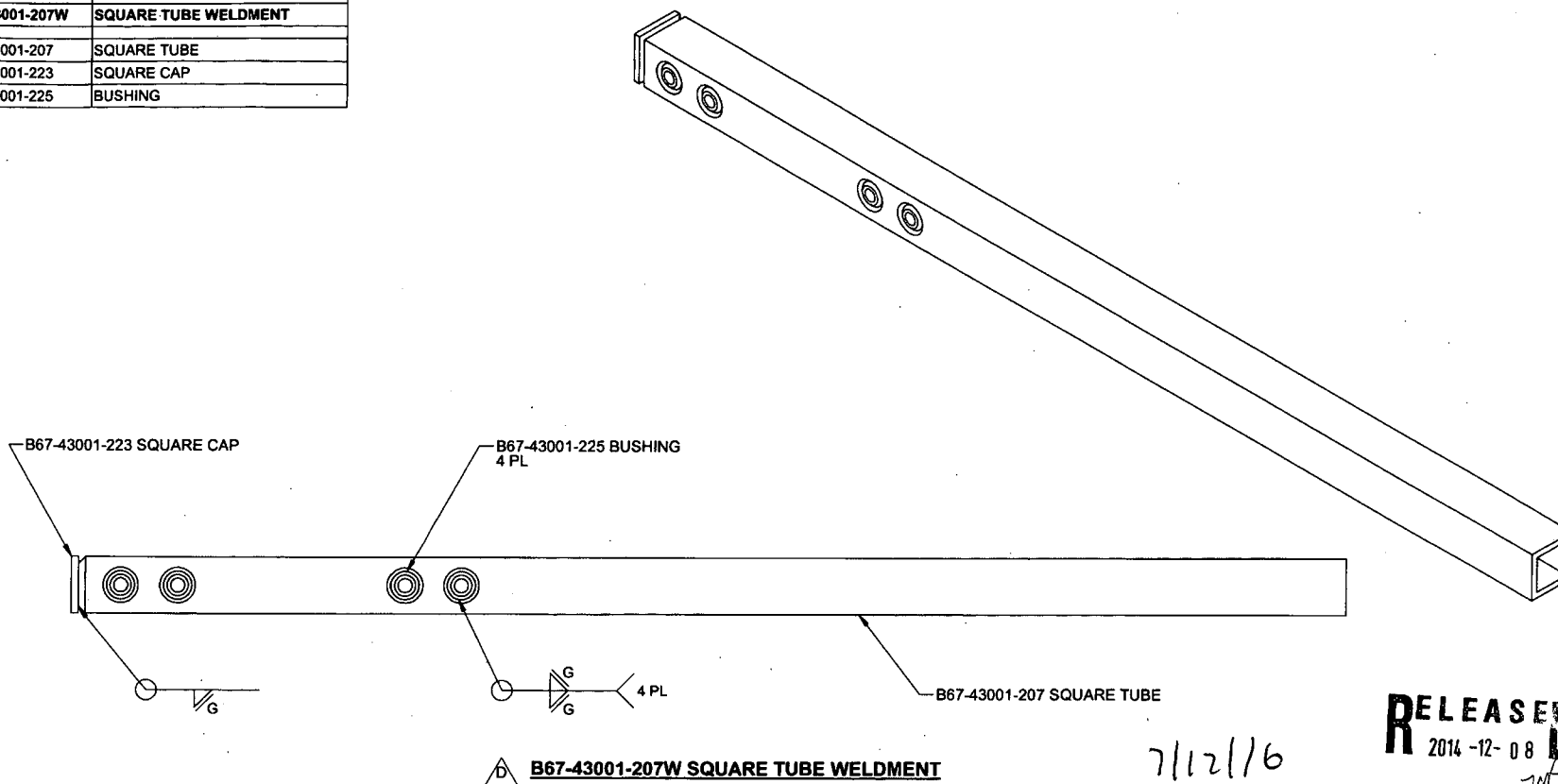
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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OTHER : _____					

ITEM	QTY -207W	P/N	DESCRIPTION
	X	B67-43001-207W	SQUARE TUBE WELDMENT
1	1	B67-43001-207	SQUARE TUBE
2	1	B67-43001-223	SQUARE CAP
3	4	B67-43001-225	BUSHING



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs
- 8) WELDING: PER DART QSI 004

RELEASED
2014-12-08

D	ADD -207W WELDMENT. REMOVE CHAMFER (ZNC4-2) REASON: TO FACILITATE MANUFACTURING	DB	14.07.22
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 16 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.02.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		B67-43001-207	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	SQUARE TUBE	NTS
DATE	14.07.22	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

0.13 X 45° CHAMFER

Ø0.500 THRU
Ø0.625 X 45° CHAMFER
TYP BOTH SIDES
4 PL

0.750

1.750

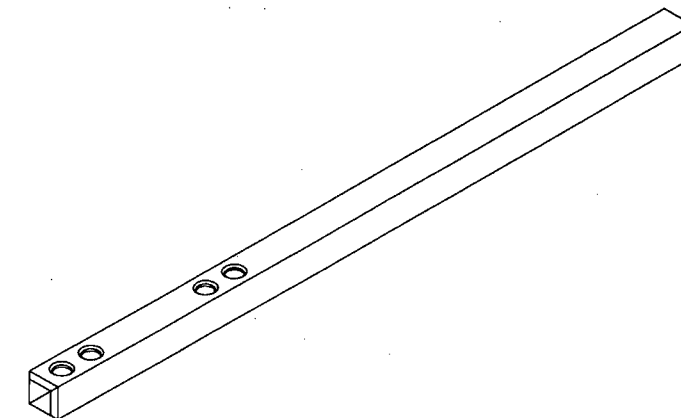
5.750

6.750

0.500

22.25

B67-43001-207 SQUARE TUBE



0.13 TYP
REF



1.00 TYP
REF

RELEASED
2014-12-08

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6TS1.000W0.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.92 lbs

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		B67-43001-207	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	SQUARE TUBE	NTS
DATE	14.07.22	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	